

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-008920**Date Inspected:** 16-Sep-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Chen Xi**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Crossbeams**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance Inspector (QA) Steve Hall was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island, in Shanghai, China. QA observed and/or found the following:

OBG CROSS BEAM CB1

This QA observed that no significant work was being performed on this crossbeam during the time QA was present.

OBG CROSS BEAM CB2

This QA observed that no significant work was being performed on this crossbeam during the time QA was present.

OBG CROSS BEAM CB3

This crossbeam has been loaded on the ship.

OBG CROSS BEAM CB4

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This QA observed that no significant work was being performed on this crossbeam during the time QA was present.

OBG CROSS BEAM CB5

This QA observed that no significant work was being performed on this crossbeam during the time QA was present.

OBG CROSS BEAM CB6

This QA observed that no significant work was being performed on this crossbeam during the time QA was present.

OBG CROSS BEAM CB7

This QA observed two ABF inspectors performing Visual Testing (VT) on the inside of this crossbeam. No other significant work was observed on this crossbeam during the time QA was present.

OBG CROSS BEAM CB8

This QA observed ZPMC qualified welding personnel identified as 070007 perform SMAW repair welding on various welds on this crossbeam. ZPMC QC identified as Mr. Liu Cheung Gang was present to monitor the welding process. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-P-2113.

OBG CROSS BEAM CB9

This QA observed ZPMC qualified welding personnel identified as 220688 perform FCAW welding on weld joint identified as CB202A-009-002. ZPMC QC identified as Mr. Liu Cheung Gang was present to monitor the welding process. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2232-Tc-U4b-F.

This QA observed ZPMC qualified welding personnel identified as 048625 perform FCAW welding on weld joint identified as FB205-022-037. ZPMC QC identified as Mr. Liu Cheung Gang was present to monitor the welding process. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2232-Tc-U4b-F.

OBG CROSS BEAM CB10

This QA observed ZPMC QC performing dimensional inspection on this crossbeam. It appeared they were checking the flatness of the bottom panel using a string-line and tape measure. No other significant work was observed on this crossbeam during the time QA was present.

OBG CROSS BEAM CB11

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This QA observed that no significant work was being performed on this crossbeam during the time QA was present.

OBG CROSS BEAM CB12

This QA observed ZPMC qualified welding personnel identified as 066687 perform FCAW welding on weld joint identified as CB201G-035-006. ZPMC QC identified as Mr. Guo Yan Fei was present to monitor the welding process. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2133.

OBG CROSS BEAM CB13

This QA observed that no significant work was being performed on this crossbeam during the time QA was present.

OBG CROSS BEAM CB14

This QA observed that no significant work was being performed on this crossbeam during the time QA was present.

OBG CROSS BEAM CB15

This QA observed ZPMC personnel fitting floor beam sections to the side panels of this crossbeam. This QA also observed ZPMC QC Ultrasonic Testing (UT) technician performing first time repair (R1) UT on several of the crossbeam floor beam corner sections. QA observed that the technician appeared to have rejected the following previously repaired welds: FB204-047-025, 028 and 031, FB204-046-021, FB204-045-021, FB204-046-040 and 046, FB204-045-024 and FB204-045-046. This QA observed that the technician did not appear to be indicating on the material that the R1 repairs were rejected. This QA requested that he mark the welds as R1 rejected on the material near the applicable welds in accordance with the contract documents. The technician complied with QAs request.

OBG CROSS BEAM CB16

This QA observed that no significant work was being performed on this crossbeam during the time QA was present.

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.

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Summary of Conversations:

As mentioned above.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang (15000422372), who represents the Office of Structural Materials for your project.

Inspected By:	Hall,Steven	Quality Assurance Inspector
Reviewed By:	Prue,Erik	QA Reviewer
